

Date: Thursday, 5/3/2007 11:39:33 AM  
 User: Kim Johnston

## Process Sheet

|  |   |
|--|---|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : BRACKET ASS'Y            |
| Job Number : 32208                             |   |
| Estimate Number : 12523                        |   |
| P.O. Number : <i>N/A</i>                       | Part Number : D35313                    |
| This Issue : 5/3/2007 S.O. No. : <i>N/A</i>    | Drawing Number : UNDER REVIEW <i>CB</i> |
| Prsht Rev. : NC                                | Project Number : <i>N/A</i>             |
| First Issue : <i>N/A</i>                       | Drawing Revision : <i>N/A</i>           |
| Previous Run : 31172                           | Material : <i>N/A</i>                   |
| Written By : <i>[Signature]</i>                | Due Date : 5/28/2007                    |
| Checked & Approved By : <i>[Signature]</i>     | Qty: 3 Um: Each                         |
| Comment : Est Rev: A New Issue 06-09-06 EC     |   |

## Additional Product

Job Number:



|         |                       |              |
|---------|-----------------------|--------------|
| Seq. #: | Machine Or Operation: | Description: |
|---------|-----------------------|--------------|

|     |             |                    |
|-----|-------------|--------------------|
| 1.0 | M6061T6S040 | 6061-T6 .040 Sheet |
|-----|-------------|--------------------|



Comment: Qty.: 0.1379 sf(s)/Unit Total: 0.4136 sf(s)

6061-T6 .040 Sheet

(M6061T6S040)

Batch: *M100 742**SAD 07/05/08*

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET

1-Cut as per Dwg D3531

Dwg Rev: *Prel*Prog Rev: *Prel**SAD 07/05/08**(3)*

2-Deburr if necessary

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/05/08**(3)*

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

*SAD 07/05/08**(3)*

|     |             |                               |
|-----|-------------|-------------------------------|
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

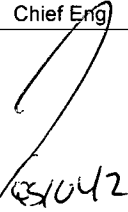



Deburr if necessary.

*N/A Done @ Seq. 2.0*

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 07/05/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR:     |      | WORK ORDER NON-CONFORMANCE (NCR)                      |   |                                 |                  |   |   |   |
|----------|------|---|---|---------------------------------|------------------|---|---|---|
| DATE     | STEP | Description of NC<br>Section A                        | Corrective Action Section B   |                                 |                  | Verification<br>Section C   | Approval<br>Chief Eng   | Approval<br>QC Inspector  |
|          |      |   | Initial<br>Chief Eng  | Action Description<br>Chief Eng | Sign &<br>Date   |   |   |   |
| 07/05/08 | 2.0  | Program malfunction<br>hole were to big<br>(one part) | <br>1051042 | Scrap destroy and replace       | 5/11<br>07/05/08 | <br>07/05/08 | <br>1051042 | <br>07/05/08 |
|          |      |   |   |                                 |                  |   |   |   |
|          |      |   |   |                                 |                  |   |   |   |

NOTE: Date & initial all entries

Date: Thursday, 5/3/2007 11:39:33 AM

User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASS'Y

Job Number: 32208

Part Number: D35313

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Bend as per Dwg D3530

3B 07/05/17

(3)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2005-23 (3)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FD/SL

07/05/24 (3)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 7/5/24 (3)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

ST115

ENGINEERING  
APPROVAL

PC 7/5/24

(3)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

PC 07/05/24 (3)

Job Completion



PC 07/05/24

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: ☒ Yes ☐ No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

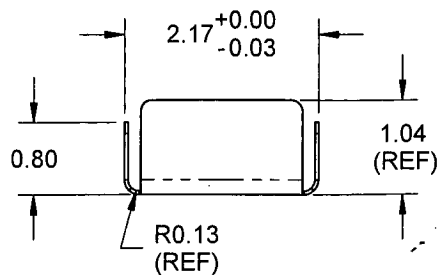
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

PRELIMINARY ISSUE

|                  |                           |   |                        |
|------------------|---------------------------|---|------------------------|
| DESIGN<br>CB     | DRAWN BY<br>CB            | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>PH    | APPROVED                  | DRAWING NO.<br>D3531                              | REV. A<br>SHEET 3 OF 3 |
| DATE<br>07.01.10 | TITLE<br>BRACKET.ASSEMBLY |   | SCALE<br>1:2           |

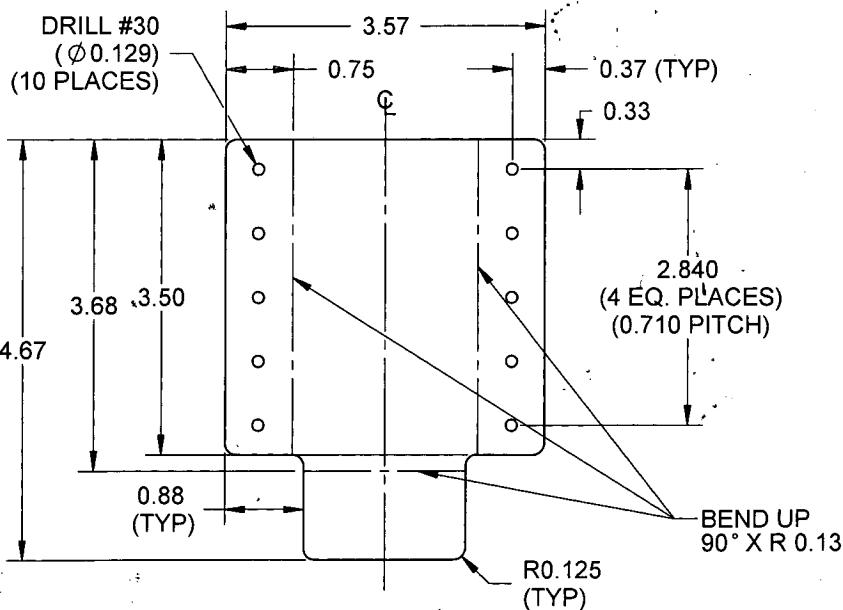
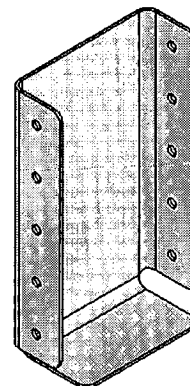


**D3531-3 BEND DETAIL**

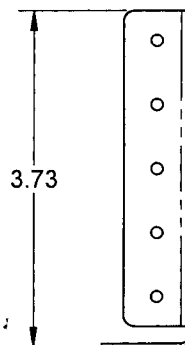
**UNDER REVIEW**

07.05.04 CB

Aug not released



**D3531-3F FLAT PATTERN**



**D3531-3 BEND DETAIL**

**D3531-3 BRACKET FRONT PLATE**

**NOTES:**

- 1) MATERIAL: ALUMINUM 6061-T6/T62 SHEET, 0.040 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX
- 6) PART IS SYMMETRIC ABOUT  $\phi$

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WITHOUT NOTICE

WORK ORDER  
NO. 32208

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|                                  |  |                      |
|----------------------------------|--|----------------------|
| DART AEROSPACE LTD               |  | Work Order: 32 208   |
| Description: BRACKET ASS'Y       |  | Part Number: D3531.3 |
| Inspection Dwg: D35313 Rev: PREL |  | Page 1 of 1          |

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Inspection Sheet<br>Drawing Dimension | Tolerance        | Actual<br>Dimension | Accept | Reject | Method of<br>Inspection  | Comments |
|---------------------------------------|------------------|---------------------|--------|--------|--------------------------|----------|
| A 4.67                                | +/- 0.030        | 4.67                | ✓      |        | Vern                     |          |
| B 3.50                                | +/- 0.030        | 3.50                | ✓      |        | Vern                     |          |
| C 0.88                                | +/- 0.030        | 0.87                | ✓      |        | Vern <sup>Vertical</sup> |          |
| D 2.840                               | +/- 0.010        | 2.834               | ✓      |        | Vern                     |          |
| E 3.57                                | +/- 0.030        | 3.57                | ✓      |        | Vern                     |          |
| F 0.37                                | +/- 0.030        | 0.37                | ✓      |        | Vern                     |          |
| G 0.33                                | +/- 0.030        | 0.33                | ✓      |        | Vern                     |          |
| H 0.040                               | +/- 0.010        | 0.038               | ✓      |        | Vern                     |          |
| I 0.129                               | +0.005<br>-0.001 | 0.133               | ✓      |        | Vern                     |          |
| J                                     |                  |                     |        |        |                          |          |
| K                                     |                  |                     |        |        |                          |          |
| L                                     |                  |                     |        |        |                          |          |
| M                                     |                  |                     |        |        |                          |          |
| N                                     |                  |                     |        |        |                          |          |
| O                                     |                  |                     |        |        |                          |          |
| P                                     |                  |                     |        |        |                          |          |
| Q                                     |                  |                     |        |        |                          |          |
| R                                     |                  |                     |        |        |                          |          |
| S                                     |                  |                     |        |        |                          |          |
| T                                     |                  |                     |        |        |                          |          |
| U                                     |                  |                     |        |        |                          |          |
| V                                     |                  |                     |        |        |                          |          |
| W                                     |                  |                     |        |        |                          |          |
| X                                     |                  |                     |        |        |                          |          |
| Y                                     |                  |                     |        |        |                          |          |

|                  |                |                     |
|------------------|----------------|---------------------|
| Measured by: SAM | Audited by: BF | Prototype Approval: |
| Date: 07/05/08   | Date: 07-05-08 | Date: 07-05-08      |
| Rev              | Date           | Change              |
|                  |                | New Issue           |
|                  |                | Revised by KJ/RF    |
|                  |                | Approved            |